Work Orde		0997		*110997*								•	Page 1
Revision ID:	D3575-6 Cargo Floor Pr	rotector	A	Accept	*N	900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: 7 Required Date: 7 Reference:	1/08/14 1/08/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			ust Item I ustomer:	D:						
		n: <u>MLJ</u>	Date: 4-0 - 0	Tooling: _ SPC (Y/N):			ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center ID	<u> </u>	Operation Description		Set Up/ Run Hours	,	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr											
D3575	Rev	A											
*100 *100* Waterjet FLOW CNC Waterje	t	FLOW WATER JET Memo 1-Cut as per Deburr if ne	Dwg D3575 Dwg Rev: cessary	0.00 0.00 <u>A</u> Prog Rev:	<u>A</u> 2-						0_		Jm14-02-3
110 *110* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00						6			<u>Jm14-07-3</u>

120

120

Memo

QC8- Inspect parts - second check

Quality Control

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / U				_	AEROSPACE
QA Closed:			Date:				_				Nork Orde	r update only	<u></u>	
Work Orde	er:					DISPOSITION				AGAINST [EPARTME	NT/PROCESS		
	•					Rework			Skid-tube	Crosstube		Water Je	t	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Prod. Eng. Coor		Quality
						Use-as-is		Therr	moforming	Finishing	Rec/S	Store/Packaging	3	Other
NCR I	lo.					Suspected Unapproved			Large Fab	Composite		Supplie	<u>ا</u> _	
Root					Desci	ription of work order update	ı	nitial	Act	ion	Sign 8			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	on	QC Inspector
Design												i		
Doc/Data											}			
Equip/Tooling														
Handling/Pre														
Material			1											
Operator														
Offset/Setup							Ì							
Process														
Supplier											1			
Training														
Transport														
Unapproved					<u> </u>		<u> </u>			•				
							FA	ULT CA	TEGORY					
Landi	_					General	_	1	_	Г	–		_	1
		Bending	_		<u> </u>	Bend	<u> </u>	1 .	Program	-		Dimensions	\vdash	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		-		der tolerance	<u> </u>	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa			Part Inco		\vdash	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	1	ion Incomplete/U	· -	Part Lost		\vdash	Weld
		Cuffs			\vdash	Contamination	<u> </u>	4	tions Incomplete/l	Jnclear	Part Mo		L	Wrong Stock Pulled
		Crushing			_	Countersink		- 1	gned/off center			ed Wrong	_	1
	-	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislab		L	Power Lo	oss/Surge	L	Other
	_	Inspection	•	Tube	<u> </u>	Drawing		Misrea			****			
		Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set						
	<u> </u>	Turning S			<u> </u>	Finish	<u> </u>	4	Calibration					
		Wave/Tw	<u>ist in T</u> ub	oe		Fit/Function	L	Out of	Sequence					

Work Orde	r ID 110997
------------------	-------------

Packaging

110997

Page 2

January-08-14 12:49:18 PM Accept D3575-6 Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Cargo Floor Protector *1* Start Oty: 1.00 **Start Date:** 1/08/14 **Cust Item ID:** Required Date: 1/08/14 **Rea'd Oty:** 1.00 *1* **Customer:** Reference: Run Start **Tooling:** Approvals: Process Plan: Date: Date: Stop SPC (Y/N): QC: Date: Date: Tool # Plan Sequence ID/ Operation Set Up/ Tool ID Accept Reject Reject Insp. Stamp **Work Center ID** Description **Run Hours** Code Qty Qty Number 130 0.00 Small Fab *130* Small Fab Memo Small Fab Deburr if necessary. QC5- Inspect part completeness to step of W/O 140 *140* QC 0.00 Memo **Quality Control** 150 Identify as per dwg & Stock Location: 0.00 14/12/3 (1) *150* PPP110878 Packaging Memo

DQA:			Date:			- JART								
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		ork Order up	ndate only	7	AEROSPACE
Q. v. c.loseu.			- Dute.			D.O.D.O.O.T.O.V.						•		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	_	
	•					Rework			Skid-tube C	rosstube		Water Jet] E	ngineering
Part N	Ю.					Scrap		l .	~ 	mall Fab	4	d. Eng. Coor.		Quality
NCR I	۱o. ِ					Use-as-is Suspected Unapproved		Therr	· —	Finishing mposite	Rec/Stor	e/Packaging Supplier		Other
Root		·			Desc	ription of work order update	П	nitial	Action		Sign &	·	1	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	on	Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material													1	
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport							1							
Unapproved				<u> </u>			EAL	III T CA	<u> </u> Tegory		<u></u>			
Landi	na G	Gear				General	FA	OLI CA	IEGONI					
Latiui	lig (Bending				Bend]Folio/I	Program		Outside Dim	ensions [$\neg_{Pr_{\epsilon}}$	essure/Forced
	Н	Centre No	nt Concer	ntric	-	BOM/Route	\vdash	Grain	ТОВГИПП		Over/Under	<u> </u>	_	t-up
		Cracks	JC 0011001		\vdash	Broken/Damage/Defect	┢	Hardwa	are		Part Incorred	<u></u>	_	mperature/Cure
	一	Crimp/Kir	nk/Ripple	/Wave		Burrs	\vdash	4	ion Incomplete/Unqua	lified	Part Lost/Mi	⊢	Twe	-
	-	Cuffs				Contamination		1 '	tions Incomplete/Uncle		Part Moved	F	-	ong Stock Pulled
	_	Crushing				Countersink		4	gned/off center		Positioned V	ட Vrong	_	-
	_	Heat Trea	nt			Cut Too Short		Mislab	-		Power Loss/	_	Otl	her
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	ŧ		-		
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence					

Work Orde January-08-14				*11(1997*							Page 3
Item ID: Revision ID: Item Name:	D3575-6 Cargo Floor	Protector		Accept	*N900	040	100) *	Setup	Start Stop		S1*
Start Date: Required Date: Reference:	1/08/14 1/08/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					ı v.	
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):		ate:				Start Stop		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Reje Qty		Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

160

160

Quality Control

MLJ 14-02-03

DQA:			Date:											
			_			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:						-	W	ork Order up	date only		
Work Ord	er.					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS		
Work Ora	-					Rework	1 1		Skid-tube Crosstube	\Box	1	Water Jet	Engineering	
Part I	No.					Scrap			Machining Small Fal	_	Pro	d. Eng. Coor.	Quality	
	•					Use-as-is	i		noforming Finishin			e/Packaging	Other	
NCR	No.			=		Suspected Unapproved			Large Fab Composite	-]	Supplier		
Root	T			<u>-</u>	Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design														
Doc/Data														
Equip/Tooling	Ш													
Handling/Pre	Ш						1							
Material	Щ													
Operator	Ш							•						
Offset/Setup	Ш													
Process	Ш													
Supplier							ŀ							
Training														
Transport	Щ													
Unapproved					<u> </u>		<u> </u>							
							FA	ULT CA	regory					
Land		I				General] <i> </i>	N	_	٠ م	т	¬	
	Н	Bending				Bend	\vdash	•	Program	\vdash	Outside Dim	 	Pressure/Forced	
	Н	Centre No	ot Concer	itric	-	BOM/Route		Grain		┝	Over/Under	-	Set-up	
		Cracks	.l./Dimmla	/\A1==	\vdash	Broken/Damage/Defect		Hardwa		\vdash	Part Incorred		Temperature/Cure	
1	Н	Crimp/Kir Cuffs	ık/kıbbie	, wave	\vdash	Burrs Contamination	\vdash	1 '	ion Incomplete/Unqualified	-	Part Lost/Mi Part Moved	ssilig	Weld Wrong Stock Bulled	
	\vdash	l			-	Countersink	-	4	tions Incomplete/Unclear gned/off center	\vdash	Positioned V	Vrong L	Wrong Stock Pulled	
	Н	Crushing Heat Trea	.+		-	Cut Too Short	\vdash	Mislabe		\vdash	Power Loss/		Other	
	H	Inspection		Tubo	-	Drawing	-	Misrea		<u> </u>	Ti owei ross)	Duige L	Joiner	
	\vdash	Marks/Ch		iune	-	Drill Holes	\vdash	Off-set						
	\Box	1,4101 (2) (1)			<u> </u>		\vdash	4						
		Turning S	equence		1	Finish		Out of	Calibration					

January-08-14 12:49:18 PM

Work Order ID:

110997

Parent Item:

D3575-6

Parent Item Name:

Cargo Floor Protector

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A New Issue 07.07.23

EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	HEET	Purchased	No			100	sf	1,461.9900	10.666	(12)		Jm	14-02-3

Location Loc Code Loc Oty MAT019 1461.99 906 124866 m126425 555.99 127934

127934

DQA:			Date:										DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Vork Order uj	ndate only	AEROSPACE
QA Closea.			Date.				_		<u> </u>			· 1	
Work Orde	er:					DISPOSITION				AGAINST [EPARTMENT	/PROCESS	
	•					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	Ю.					Suspected Unapproved			Large Fab	Composite		Supplier	
Root	T				Desc	ription of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	•	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design						· · · · · · · · · · · · · · · · · · ·							
Doc/Data													
Equip/Tooling									<u> </u>				
Handling/Pre													
Material													
Operator													,
Offset/Setup			ļ										
Process													
Supplier													
Training													
Transport													
Unapproved			<u> </u>		<u> </u>		<u> </u>					<u> </u>	
							FA	ULT CA	TEGORY				
Landi	ng (1			_	General		1	_	г	–	. —	٦
	<u> </u>	Bending			_	Bend	<u> </u>	-	Program		Outside Dim		Pressure/Forced
		Centre No	ot Concer	ntric	_	BOM/Route	<u> </u>	Grain			Over/Under	 	Set-up
	<u> </u>	Cracks			-	Broken/Damage/Defect	_	Hardwa		}	Part Incorre	·	Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	:/Wave	_	Burrs	\vdash	1 1	ion Incomplete/U		Part Lost/M	· ·	Weld
	\vdash	Cuffs			<u> </u>	Contamination	\vdash	-	tions Incomplete/		Part Moved		Wrong Stock Pulled
	\vdash	Crushing			<u> </u>	Countersink	\vdash		gned/off center	}	Positioned	· ·	7 045
	_	Heat Trea			\vdash	Cut Too Short	-	Mislab		L	Power Loss,	Surge	Other
	<u> </u>	Inspectio		Tube	<u> </u>	Drawing	\vdash	Misrea					
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set			-		
	<u> </u>	Turning S			 	Finish		4	Calibration				
	1	Wave/Tw	ist in Tul	oe e	1	Fit/Function	1	Out of	Sequence				

DART AEROSPACE LTD	Work Order:	110997
Description: Cabin Floor Protector	Part Number:	D3575-6
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension				٠ ـــــ
Ø3.00	+0.006/-0.001	3.006	_		ν	Jkmoi
3.38	+/-0.030	3.38"	-		V	
6.50	+/-0.030	6.50"	-		T	Jemol
26.13	+/-0.030	26.13	-		ナ	
30.13	+/-0.030	30.13"	_		T	
2.00	+/-0.030	2.00"	-		V	
3.50	+/-0.030	3.50"	_		7	
14.25	+/-0.030	14.25	-		丁	
25.13	+/-0.030	25.1.3"	-		T	
29.38	+/-0.030	29.35"	_		Τ	
30.38	+/-0.030	30.35	-		Τ	
31.50	+/-0.030	31.50"	-		T	
1.00	+/-0.030	1.000	-		ν	
4.38	+/-0.030	4.39"	-		V	
14.50	+/-0.030	14.50	-		T	
16.00	+/-0.030	16 000	_		†	
23.13	+/-0.030	23./3"	-		I	
26.88	+/-0.030	26.85"	_		7	
27.69	+/-0.030	27.69"	_		7	
1.00	+/-0.030	1,00"	_		ν	
3.75	+/-0.030	3.75"			V	
9.63	+/-0.030	9.63°			7	
16.13	+/-0.030	16.00	-		T	
28.06	+/-0.030	28.06"	_		1	
32.15	+/-0.030	32.15"	DAS		T	

Measured by: JM

Date: 14-03-3

Audited by: 9-897

Date: 14/2/5

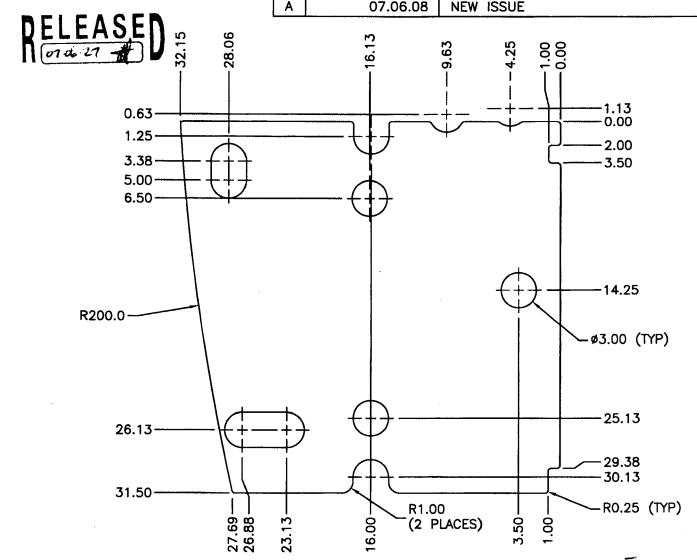
Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised	by_{LA}	Approved
Α	08.01.16	New Issue	KJ//DD	of t	
				()	



DESIGN,	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE	<u> </u>	TITLE	SCALE
07.06.08		CABIN FLOOR PROTECTOR	1:8
1 . 1			



D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

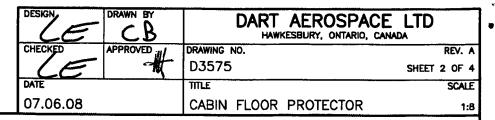
NOTES:

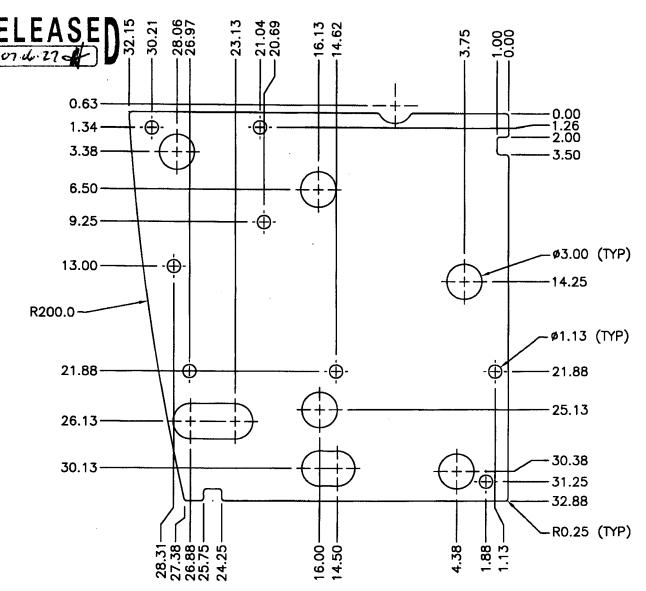
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- CHECK PER TEMPLATE DT8966

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D3575-3 CABIN FLOOR PROTECTOR

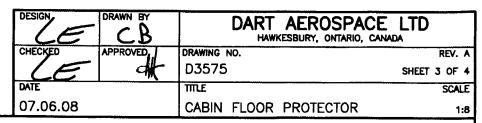
NOTES:

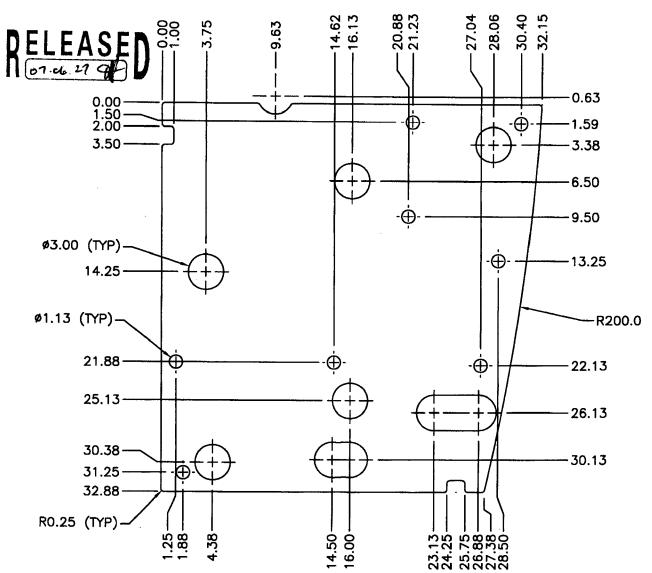
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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D3575-4 CABIN FLOOR PROTECTOR

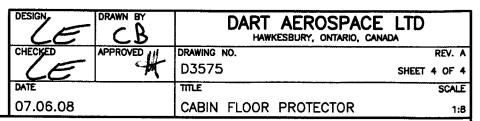
NOTES:

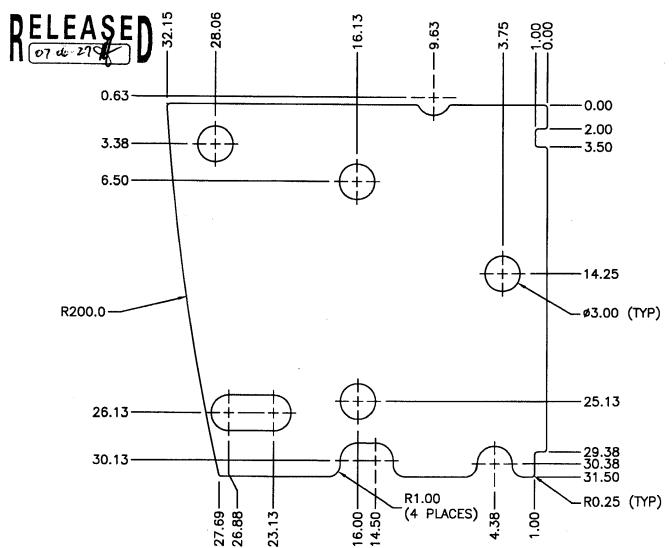
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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